

Work Order ID 78593

78593

Page 1

January-11-12 2:42:56 PM

Item ID: D2230-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 11/01/2012 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 200.00 ***200*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2230	Rev G

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut D2423 extrusion to 0.82"								
	Batch: _____								

CL 12/01/12

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA927								
	FOLIO REV: _____								
	DWG REV: _____								
	Check for crack while loading into the machine.								
	2- deburr								

CL 12/01/12 200

710.15862

issue Pro to meter
machine as per diag D 2230 REV G

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <i>rec'd</i> *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo <i>rec'd + inspect for transit damage attached c/c to w/o</i>	0.00 0.00							<i>01/12/12 (200)</i>
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>8.2 (200)</i>				<i>ccw by (200) as per</i>	
150 *150* Hand Finish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00						<i>200 Bl 12 D-13.</i>	

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

200X M-L 12/02/14

170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:15								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 11:45								

200X M-L 12/02/14

180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

200 BL 12-2-14

m11a480

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: ST 480	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

SP 12-02-14

12/2/14
MF
12-02-14

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Picklist Print

January-11-12 2:43:00 PM

Page 1

Work Order ID: 78593

78593

Parent Item: D2230-3

D2230-3

Parent Item Name: Lug

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP D00.05.18Added inspection level 8, and removed P/O for powder
coatEC IPP REV :E NEW FOLIO # 10-05-
25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		200			
D2230-3P									**				
LUG													
D2423		Manufactured	No			100	f	411.0900	0.0683	14.37895			
D2423									**				
Lug Extrusion													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				MAT006				411.09					
				43722				161.5					
				45800				1					
				68331				248.59					

10/12/12 (20)

CL 12/01/12

14.38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

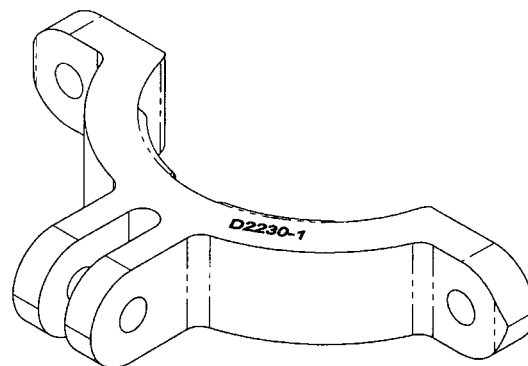
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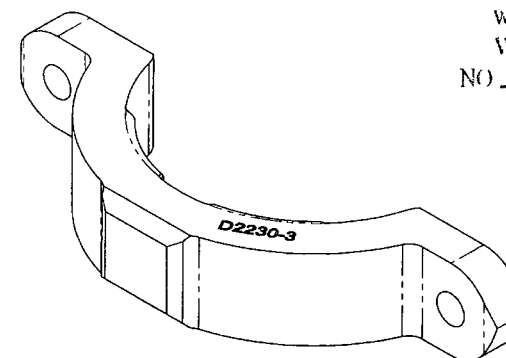
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO 78593 M.L.J
12/01/11



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/06/15 M.P.



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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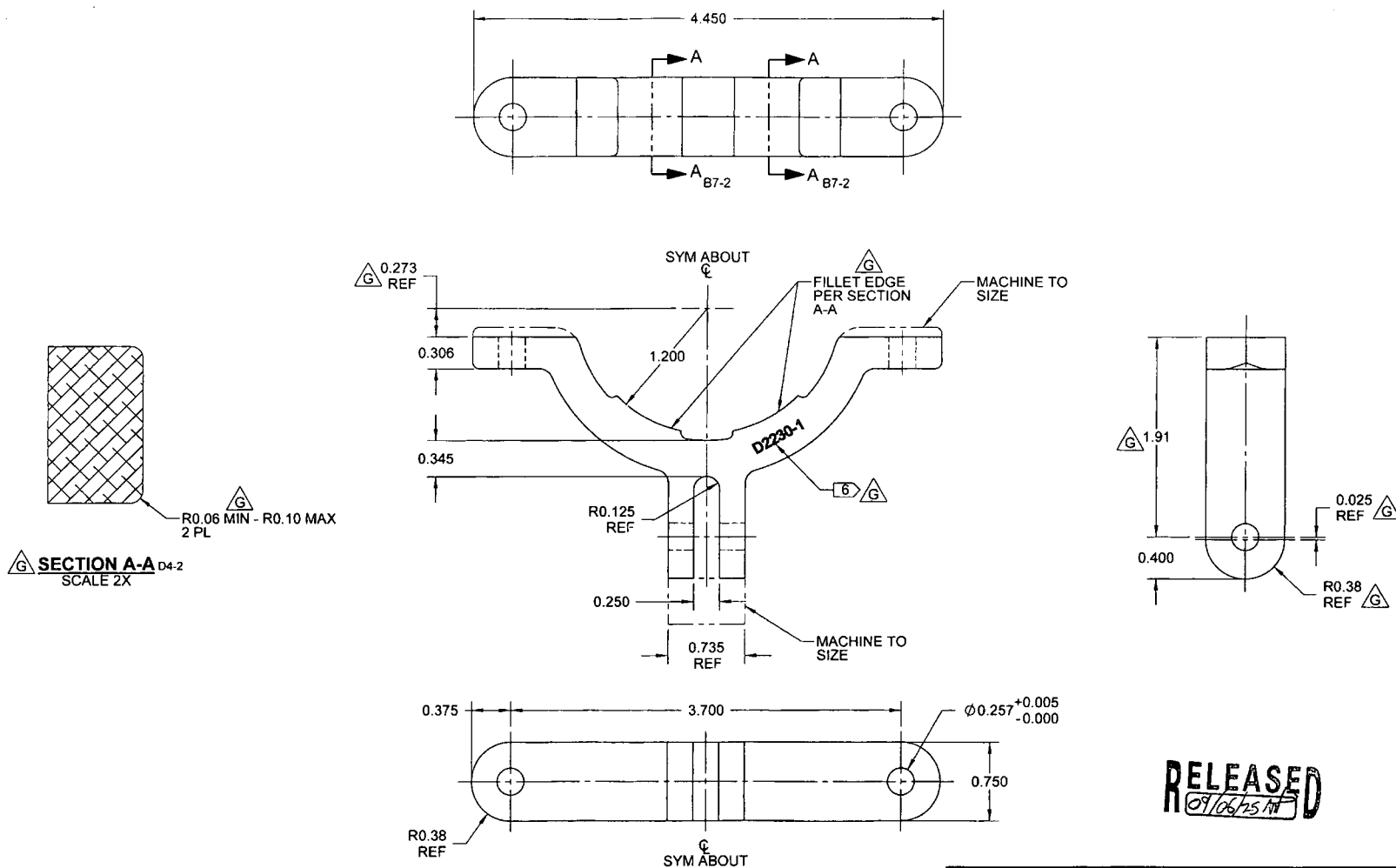
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
78593



SECTION A-A D4-2
SCALE 2X

D2230-1 MOUNTING LUG

RELEASED
09/06/25 NT

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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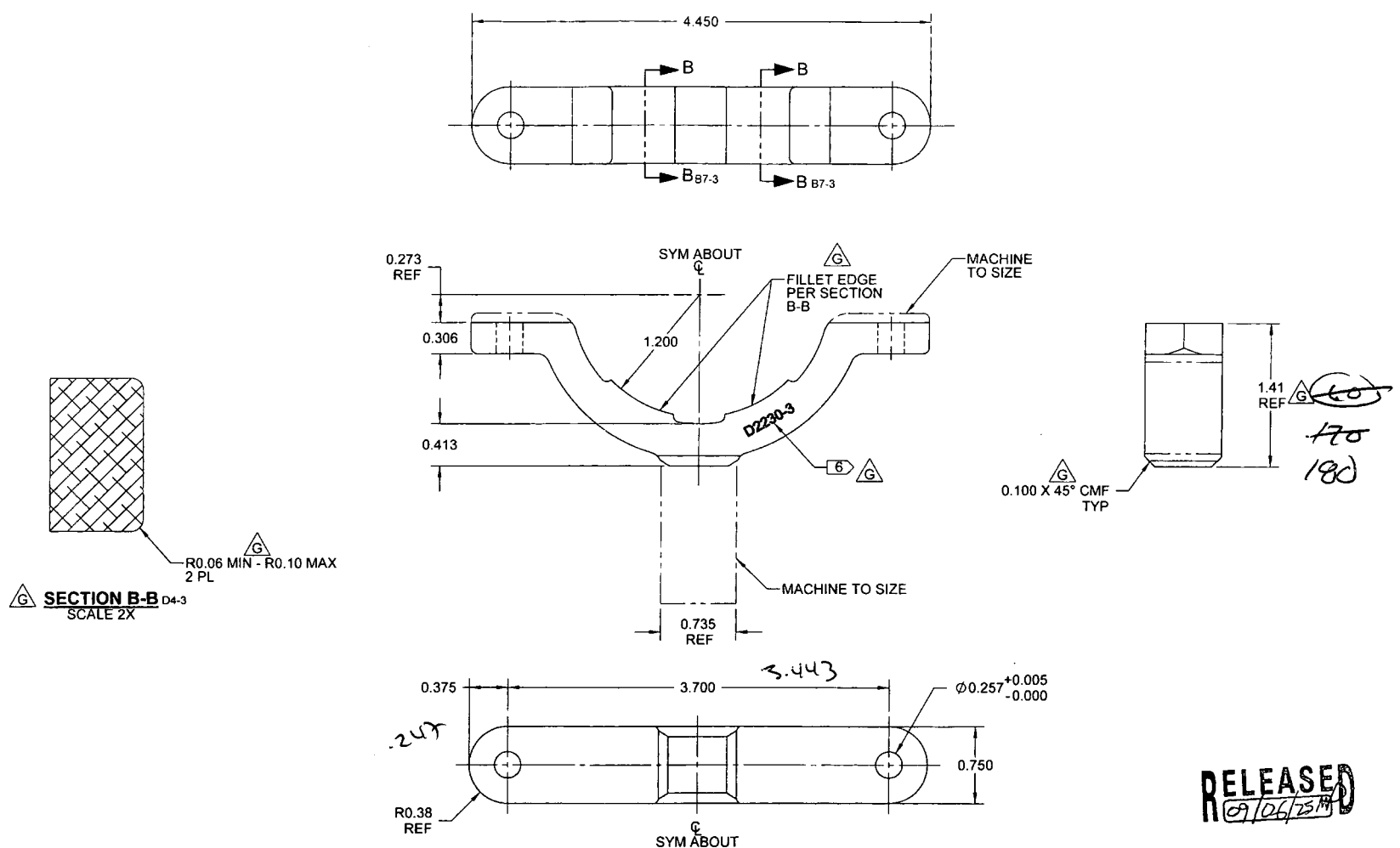
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78593



RELEASED
9/10/2011

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G SHEET 3 OF 3
MFG. APPR.		TITLE MOUNTING LUG	SCALE NTS
DE APPR.		DATE 09.01.16 COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18426**
Date: Feb 07, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 15868	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug as per drawing D2230 REV.G B78596	Each	200		
D2230-3 Mounting Lug as per drawing D2230 REV.G B78593	Each	200	200	✓

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by _____	Thank you for your order!
-------------------	---------------------------



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Mounting Lug	15868

8, 12/01/07

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, February 7, 2012